Work Order I				*77	064 *	·					Page 1
Revision ID: Item Name: Cap				Accept	*N900	<u>040</u>	100) * s	Setup Star	IVI	S1* S2*
Start Date: 25/2 Required Date: 09/2	11/2011 12/2011	Start Qty: 7.00 Req'd Qty: 7.00	•		Cust Item I	D:					
Reference:	12/2011	Req u Qiy. 7.00	*7*		Customer:					•	
Approvals: Pr	ocess Plai	n: M.L.J	Date: \\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	25 Tooling:	D:	ate:		F	Run Star	!/	R1*
QC	C:		Date:	SPC (Y/N):	D:	ate:			Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr		9		. ,					
D3262	Е	:									
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110				0.00							
110 HAAS I		HAAS CNC VERTIC Memo	AL MACHINING #1	0.00	111						
HAAS CNC vertical macl	hine #1	Machine FOLIO R DWG RE	as per dwg D3262 as per Folio FA902 and Dv EV: 4 V: 5 NG JIG DT9636		Lulialoi						

		WC	RK ORDER CHANGES	5				
STEP	PR			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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		:PAR #: Resolution: Description of NC	:PAR #:Fault Cated Resolution:Disposition WORK ORDE STEP Description of NC Section A Initial	:PAR #:Fault Category:	PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C C WORK ORDER NON-CONFORMANCE (NCI STEP Description of NC	PAR #: Fault Category: NCR: Yes No DQ/ Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	:PAR #:Fault Category:NCR: Yes No DQA: Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

Work Ord November-25-1				*770	164*						Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date:	D3262-5 Cap 25/11/2011	Start Qty: 7.00 Req'd Qty: 7.00	*7* *7*	Accept	*N900 Cust Item I Customer:		100)* s	Setup Sta	IV	S1* S2*
Reference:	. 02/12/2011	noq a Qiji 7.00	. / .		Customer:						
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ite:		R	Run Sta	17	R1*
	QC:		Date:	_ SPC (Y/N):	Da	ate:	<u>.</u>		Sto	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC2- Inspect parts off m	achine FAI/FAIB	0.00	21/12/01						•
120 QC Quality Control		Memo		0.00	Z 111 1 W 1 O J			7			-
130		QC8- Inspect parts - seco	and check	0.00	11-12-02						
130 QC Quality Control		Memo		0.00							
140 *1 4 0*		Identify as per dwg & Sto	ock Location	0.00			7.1	SP.	11-1	J-6S	- .
Packaging		Memo		0.00			TX		· · ·		

Packaging

	Dart	Aeros	pace	Ltd
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W/O:			WC	ORK ORDER CHANG	SES				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A :	Date: _	
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B	Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
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	Vork Order ID 77064 ovember-25-11 8:35:21 AM		*77064*							Page 3	
Item ID: Revision ID: Item Name: Start Date:	D3262-5 Cap 25/11/2011	Start Qty: 7.00	*7*	Accept	*N900		100)*	Setup Star	ו כימו	
Required Date: Reference:	09/12/2011	Req'd Qty: 7.00	*7*		Customer:						
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:		1	Run Start Stop	"NR1"	
Sequence ID/ Work Center II 150 *150* QC Quality Control)	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp 12 5 9 11-12-05	

									
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Part No		PAR #:	Fault Categ	jory:	,NCI	R: Yes I	No DQA:	Date: _	
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NCR:			WORK ORDE	R NON-CONFORM	MANCE	(NCR)) .		
DATE	STEP	Description of NC			ection B	Sign &	Verification		Approval
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Picklist Print

November-25-11 8:35:26 AM

Work Order ID: 77064

77064

Parent Item:

D3262-5

D3262-5

Parent Item Name: Cap

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 7.00

Required Qty: 7.00

Comments:

Item Name

IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC

Rev:B as per ECN10-571 DD 10.05.10 verified EC

IPP

ev.b as per ECIV	10-3/1 DD 10.0	3.10 V	erified .EC									
Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status

f

M6061T6B0.500X06.00

Component Item ID/

Purchased

No

100

25.1500

0.96

7.073684

M6061T6B0 500X06 000

6061-T6 Bar .500 x 6.00

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Location	Loc Qty	Loc Code
MAT004	25.15	
112567 115045	9.15	
115045	16	

7.074 and 1/10/01

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W/O:		, 	W	ORK ORDER CHANG	ES	· · · · · ·		
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DATE	STEP	Description of NC	In this I	Corrective Action Section	on B Sign &	Verification		Approval
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DART AEROSPACE LTD	Work Order:	77064
Description: Cap	Part Number:	D3262-5
Inspection Dwg: D3262 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.45	+/-0.030	.445			Vern ML-OLO	
0.25	+/-0.030	.243			л	
Ø0.875	+/-0.010	Ø. 87 L			1/	
Ø5.005	+0.010/-0.000	\$5.005			rt	
R0.063	+/-0.010	R063			R.L	
0.080	+/-0.010	. 678			- 1	
0.13	+/-0.030	.124			,,	
0.070 x 45°	+/-0.010 x 0.5°	.080 × 45°		-	11	
Ø5.165 Ref	+/-0.010	5. Blok				
1.63	+/-0.030	5. blek 1. 1.30			11	
3.25 Ref	+/-0.030	3.247			14	
9/16-18 UNF-3B	N/A	9/11,-18	_		1,	
3/4-16 UNF-3B	N/A	3/4-16				
0.091	+0.007/-0.008	.094			• • • • • • • • • • • • • • • • • • • •	
R0.03	+/-0.010	R.030			٠,	
R0.02	+0.00/-0.01	R.020				
45°	+/-0.5°	45°			. (
30°	+/-0.5°	36°			. 11	
Ø0.588	+0.005/-0.000	Ø.59b			\ r	
Ø0.696	+0.007/-0.008	5.694				
0.101	+0.008/-0.007					
R0.03	+/-0.010	.099			11	
R0.02	+0.00/-0.01	R.030				
45°	+/-0.5°	R.020			11	
30°	+/-0.5°	450			'1	
Ø0.771	+0.005/-0.000	130			11	
Ø0.882	+0.008/-0.007	Ø.775 Ø.882			1,	

Measured by:	on	Audited by:	27	Preliminary Approval:	
Date:	11/12/02	Date:	11-12-02	Date:	
Rev Date	Change			Daving d hy	Annanad

Rev	Date	Change	Revise	yd b	Approved
Α	10.06.07	New Issue	KJ	K)	- 20
				771	

W/O:			10/4	ORK ORDER CHANG)EC			· · · · · · · · · · · · · · · · · · ·	······	
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Part No	:	PAR #:	Fault Cate	gory:	_ NCF	R: Yes	No DQ	A:	_ Date: _	
	Resolution: Disposition:						osed:	4877	Date: _	
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE	(NCR)			
		Description of NC			tion B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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3 QTY ITEM P/N DESCRIPTION -041 D3262-041 CANISTER ASSEMBLY SHOP COPY D3262-1 TUBE D3262-3 RETURN TO D **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO_77064 M.C.J 11/11/25 10.88 REF FITTING HOLES Ø5.17 С REF (2) 2010 -05- 97 **D3262-041 CANISTER ASSEMBLY** 0.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5) 10.05.03 ADD D3282-043/-5 (ZN B5-2; B5-5): REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004 RF 09.12.30 Ø5.165 WAS Ø5.190 RF 06.08.31 В ADD PRESSURE TESTING OPTION МВ 05.02.14 NEW ISSUE 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED Α RF 04.05.06 REV. DESCRIPTION DATE DESIGN RF DARY AEROSPACE LTD 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. E 7) WFIGHT: 2.51 lbs D3262 MFG. APPR. SHEET 1 OF 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS TITLE APPROVED SCALE FUEL PURGE CANISTER DE APPR. NTS

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NOT TO BE USED FOR ANY PURPOSED ON COMMUNICATED TO ANY OTHER PERSON
WHITTEN PERSONS ANY OWNER APPLICATION.

DATE

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10.05.03

W/O:	<u> </u>		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	_ Date: _				
	Re	solution:	Disposition	QA: N/C CI	osed:		Date: _					
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)						
DATE	STEP	Description of NC	Corrective Action Section B			Verific		Approval	Approval			
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	on C	Chief Eng	QC Inspector			
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8 5 3 QTY -043 ITEM DESCRIPTION D3262-043 CANISTER ASSEMBLY D3262-1 TUBE D3262-5 CAP 10.88 FITTING HOLES Ø5.17 REF REF 9/16-18 UNF-3B 9 -3/4-16 UNF-3B REF 0.13 (2) **D3262-043 CANISTER ASSEMBLY**

DESIGN RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. E D3262 MFG. APPR. SHEET 2 OF 5 TITLE APPROVED **FUEL PURGE CANISTER** DE APPR NTS COPYRIGHT © 2004 BY DART AEROSPACE LTD
THE DOCUMENT IS PRIVET WIS CONFIDENTIAL AND IS SUPPLED ON THE DUMESS CONSTITUTING TO SET 100 CONFIDENTIAL AND IS SUPPLED ON THE PURPLESS CONSTITUTION TO SET 100 CONFIDENTIAL AND IS ANY PRIVINGE OF CORPORATION TO ANY PRIVINGE OF THE PRIVILENCE OF CONFIDENCE OF THE PRIVILENCE OF THE PRIVILENCE OF THE PURPLESS OF THE PRIVILENCE OF THE PRIVILENCE OF THE PURPLESS OF THE PURPLES DATE 10.05.03

1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER 6) IDENTIFICATION: IDENTIFY WITH DART PIN D3202-043 AND BING FINE FORTY

) WEIGHT: 2.50 lbs

8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR

PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

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W/O:			W	GES							
DATE	STEP	PR	OCEDURE CHA	ANGE	Ву	Da	ite Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:						
	Re	esolution:	Disposition	on:	QA: N/C	Closed	J:	Date: _	·		
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n & ite	Section C	Chief Eng	QC Inspector		
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3 Ø5.00 REF С 0.13 REF - 10.50 **D3262-1 TUBE** NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6T5.000W.125
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT 1.96 lbs DESIGN RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. E D3262 MFG. APPR. SHEET 3 OF 5 7) WEIGHT: 1.96 lbs 8) PART IS SYMMETRICAL ABOUT CENTERLINE APPROVED TITLE SCALE FUEL PURGE CANISTER

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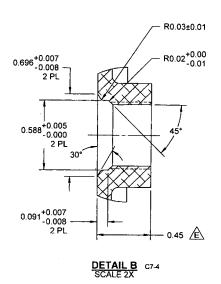
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0.25 Ø0.875 2 PL ⁴Ø5.005^{+0.010} R0.063 TYP 0.070 x 45° CHAMFER

DRILL THRU Ø0.516 (33/64 DRILL), B6-4 TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879 Ø5.165 2 PL REF 1.63 3.25 REF 6



SECTION A-A C5-4

0.13

D3262-3 CAP

NOTES:
1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M606116B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.23 MIN
7) WEIGHT: 0.28 lbs

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7) WEIGHT: 0.28 lbs 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DADT AEDOCDACE	DART AEROSPACE LTD					
DRAWN	RF	HAWKESBURY, ONTARIO, CANA						
CHECKED	₩.	DRAWING NO.	REV. E					
MFG. APPR.	9/	D3262	SHEET 4 OF 5					
APPROVED	142	TITLE	SCALE					
DE APPR.	-41-	FUEL PURGE CANISTER	NTS					
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPIDENTIAL AND IS SUPPLIED ON THE EURISES CONDITION THAT IT IS MOT TO BE USED FOR AMP PURPOSE OR COMPUTED COMMUNICATED TEXT AND OTHER PRESION WITHOUT WITHOUT PETRHASION FROM DART ARROPMED, LTD.						

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8 6 3 0.091 +0.007 -0.008 R0.03±0.01 R0.02^{+0.00} Ø0.696^{+0.007} -0.008 D Ø0.588^{+0.005} DRILL THRU Ø0.516 (33/64 DRILL), Æ 30° B7-5 TAP HOLE 0.45 Ø5.165 9/16-18 UNF-3B REF PER MIL-S-8879 Ø0.875 2 PL DETAIL D C7-5 1.63 -D c2-5 05-0.010 -0.000 3.25 REF R0.063 TYP 0.101+0.008 R0.03±0.01 R0.02^{+0.00}_{-0.01} Ø0.882^{+0.008} -E A2-5 0.070 x 45° CHAMFER 0.080 · 0.13 € TYP DRILL THRU Ø0.688 TYP (11/16 DRILL), TAP HOLE 3/4-16 UNF-3B Ø0.771+0.005 -0.000 SECTION C-C D5-5 PER MIL-S-8879 Æ 0.45 D3262-5 CAP NOTES: 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6B DETAIL E B7-5 SCALE 2X 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX DESIGN RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN CHECKED DRAWING NO. REV. E D3262 MFG. APPR SHEET 5 OF 5 7) WEIGHT: 0.27 ibs 8) PART IS SYMMETRICAL ABOUT CENTERLINE APPROVED TITLE SCALE FUEL PURGE CANISTER

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PRODUCEDT IS PRIVILLED COPPEDITION AND IS EMPLIED TO PRIVILLED COPPEDITION THAT IS
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W/O: WORK ORDER CHANGE						,				
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